

Work Order ID 140601

Friday, January 08, 2016 10:45:32 AM

140601

AS SOON AS POSSIBLE MAEIO

~~ISSUE~~

Page 1

Item ID: D5377-1

Accept

N900040100

Setup Start

NS1

Revision ID: PRELIM

Item Name: Bearpaw

Stop

NS2

Start Date: 1/8/2016

Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/8/2016

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MCS

Date: JAN 08 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5377

AA

DAS 1/16/16

Rev A

DAS 9-89 16-03-16

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.03

FLOW CNC Waterjet

Cut Blank as per D5377-1_blank File

(4)

16-01-13

130

0.01

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.05

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining

2-Machine as per FolioFB448 and Dwg

FOLIO REV: AA

DWG REV: AS

3-Deburr

3

1

DAS 20 9-89 16-01-13

Work Order ID 140601

Friday, January 08, 2016 10:45:33 AM

140601

PRELIMINARY ISSUE

Page 3

Item ID: D5377-1

Accept

N900040100

Setup Start *NS1*

Revision ID: PRELIM

Stop *NS2*

Item Name: Bearpaw

Start Date: 1/8/2016 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 1/8/2016 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.01							
Quality Control									

MAR 18 2016

FEB 16 2016

Picklist Print

Friday, January 08, 2016 10:45:37 AM

Page 1

NEW ISSUE

Work Order ID: 140601

140601

Parent Item: D5377-1

D5377-1

Parent Item Name: Bearpaw

Start Date: 1/8/2016

Required Date: 1/8/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 16-01-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No			sf	236.0730		22.31579			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

26/01/16

Location

Loc Qty

Loc Code

MAT018

236.073

m131661

1.473

m133248

23.4

m133642

211.2

26

DART AEROSPACE LTD		Work Order: 140601
Description: D5377-1 Bear paw		Part Number: D5377-1
Inspection Dwg: D5377 Rev: PA1		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.38	+/- .030	.380	✓		SLIO	VerN
5.00	+/- .030	4.995	✓		"	
7.09	+/- .030	7.090	✓		SL01	Tape
10.20	+/- .030	10.200	✓		"	
2.76	+/- .030	2.762	✓		SLIO	
7.90	+/- .030	7.900	✓		SL01	
18.19	+/- .030	18.190	✓		"	
20.94	+/- .030	20.940	✓		"	
3.93	+/- .030	3.930	✓		SLIO	
12.47	+/- .030	12.470	✓		SL01	
24.91	+/- .030	24.910	✓		"	
R.50	+/- .030	.500	✓		Rad gauge	
R.63	+/- .030	.630	✓			
1.38	+/- .030	1.375	✓		SLIO	
5.50	+/- .030	5.503	✓		"	
1.72	+/- .030	1.723	✓		"	
2.00	+/- .030	2.000	✓		"	
15.44	+/- .030	15.440	✓		SL01	
17.44	+/- .030	17.440	✓		"	
24.38	+/- .030	24.380	✓		"	
4.688	+/- .010	4.688	✓		SLIO	
.406	+/- .010	.406	✓		↓	
.645	+/- .010	.642	✓			
24.00	+/- .030	24.000	✓		SL01	
21.34	+/- .030	21.340	✓		SLIO	
6.40	+/- .030	6.403	✓			
3.60	+/- .030	3.601	✓			
3.52	+/- .030	3.517	✓			
.24	+/- .030	.240	✓			
.50	+/- .030	.495	✓			
.74	+/- .030	.742	✓			
.95	+/- .030	.948	✓			

RECEIVED 10/11/14

Measured by: 20	Checked by: 9	QC Inspector:
Date: 16-01-13	Date: 16-01-14	Date:

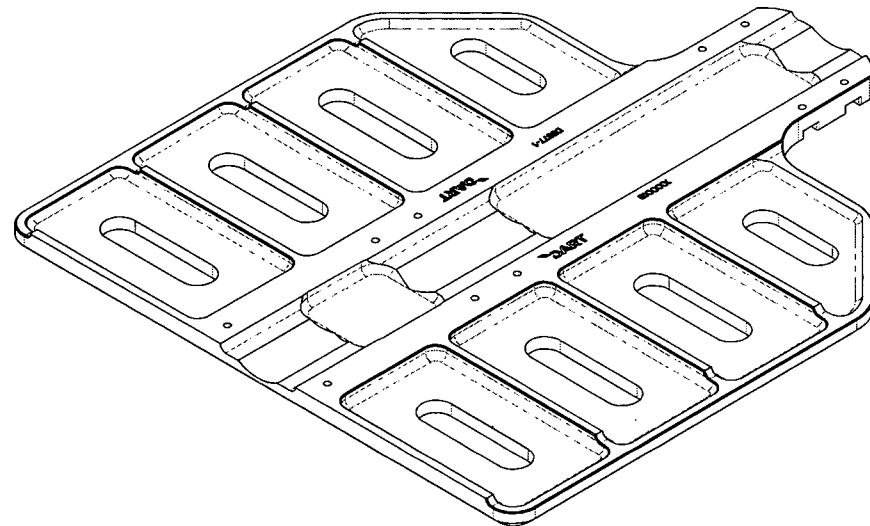
Engineering Approval: (If necessary)	Date:
---	-------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

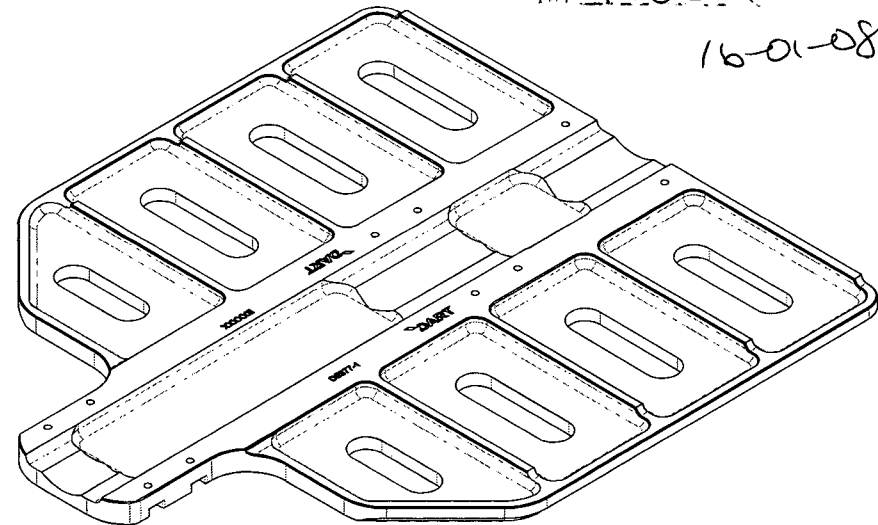
INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	K.J	

PRELIMINARY ISSUE



D5377-1 BEARPAW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO 140601 MJS

16-01-08

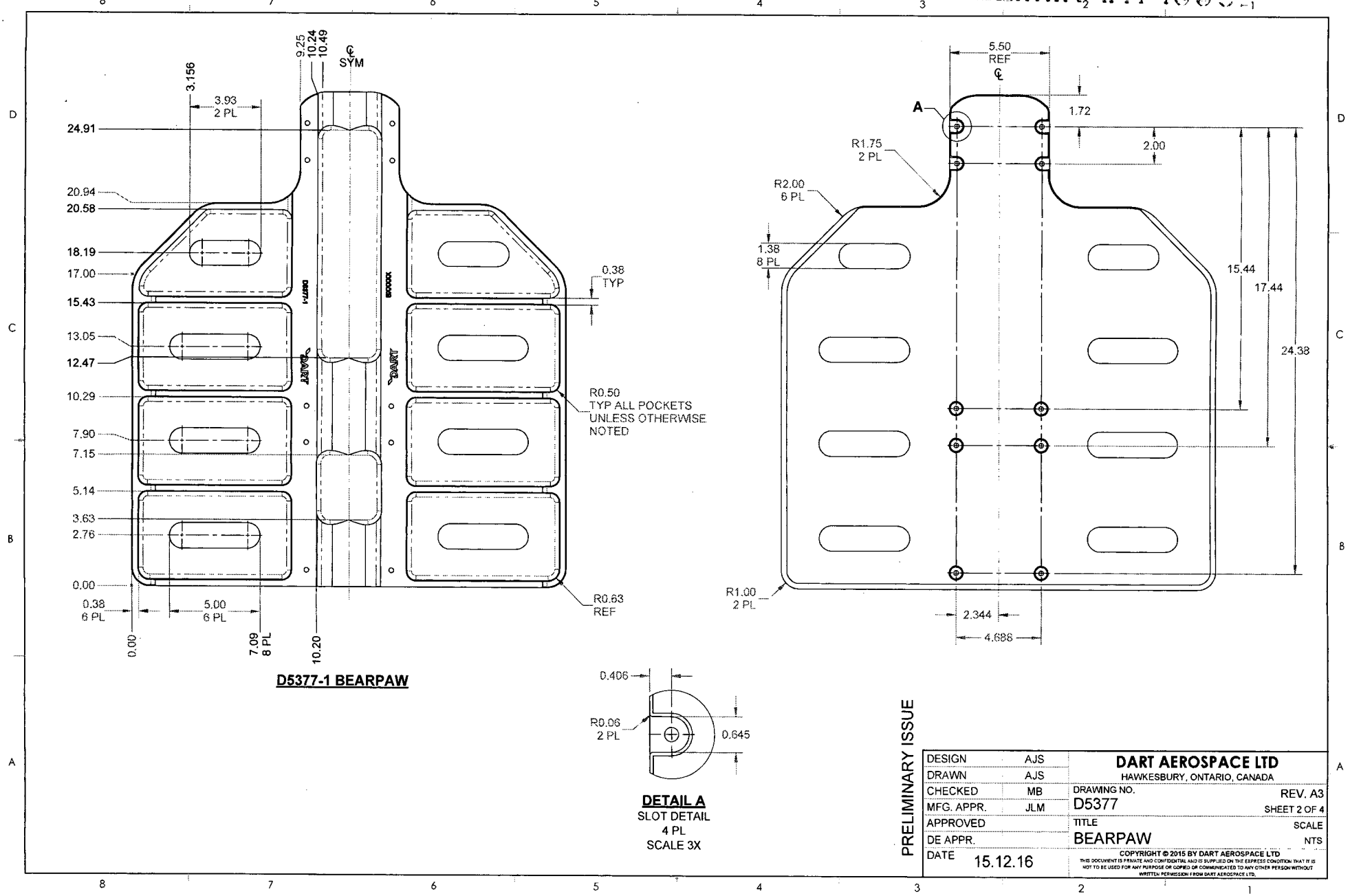
NOTES:

- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK
REF DART SPEC MUHMWB100
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 0.010 - 0.012 DP WITH A MINIMUM 0.010 RAD
- 7) WEIGHT: 9.56 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.010 - 0.012 DP WITH A MINIMUM 0.010 RAD
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE D5377-1-REVA.STP

PRELIMINARY ISSUE

A NEW ISSUE		AJS	15.12.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	MB	DRAWING NO.	REV. A3
MFG. APPR.	JLM	D5377	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BEARPAW	NTS
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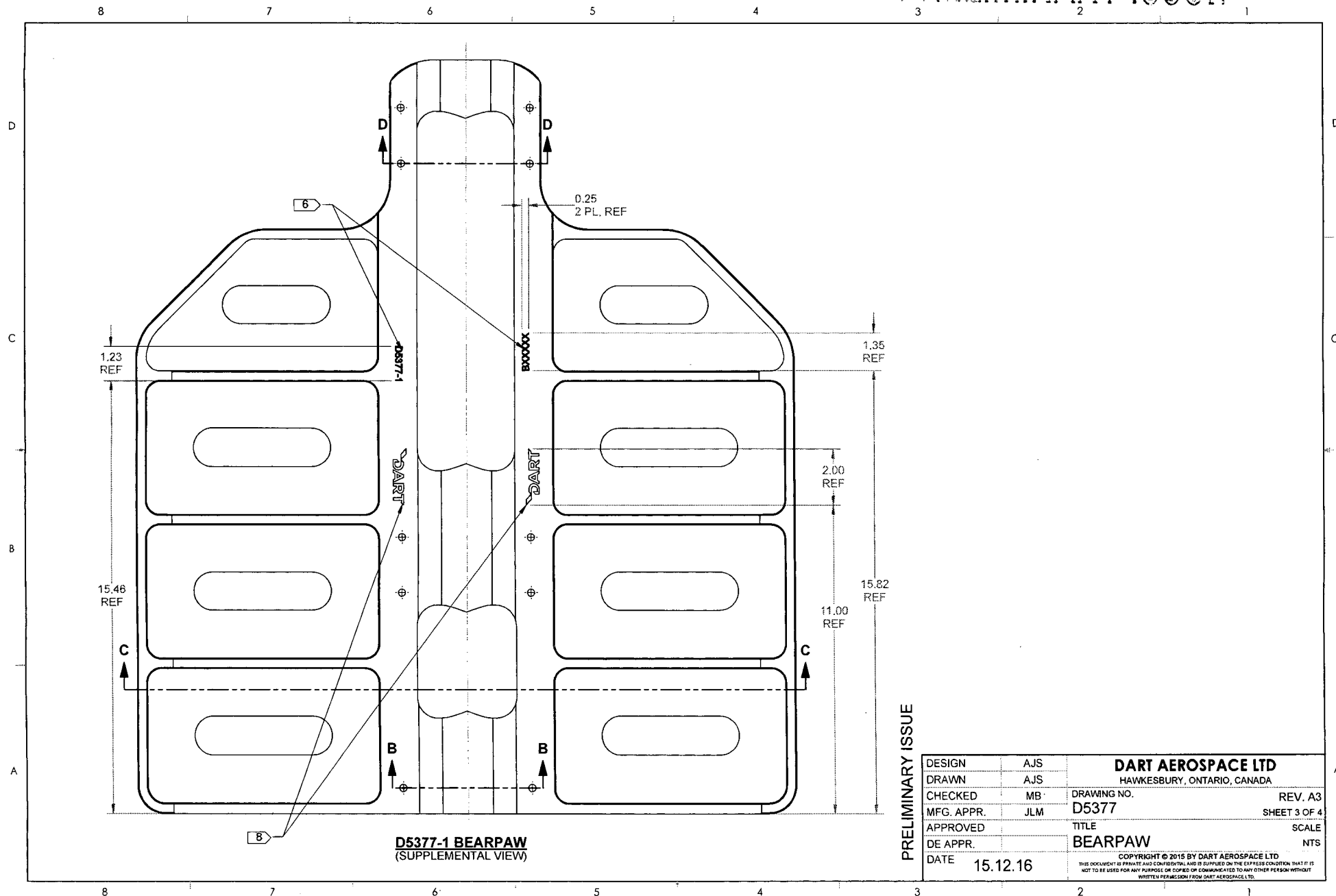
PRELIMINARY ISSUE



PRELIMINARY ISSUE

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. A3
MFG. APPR.	JLM	D5377	SHEET 2 OF 4
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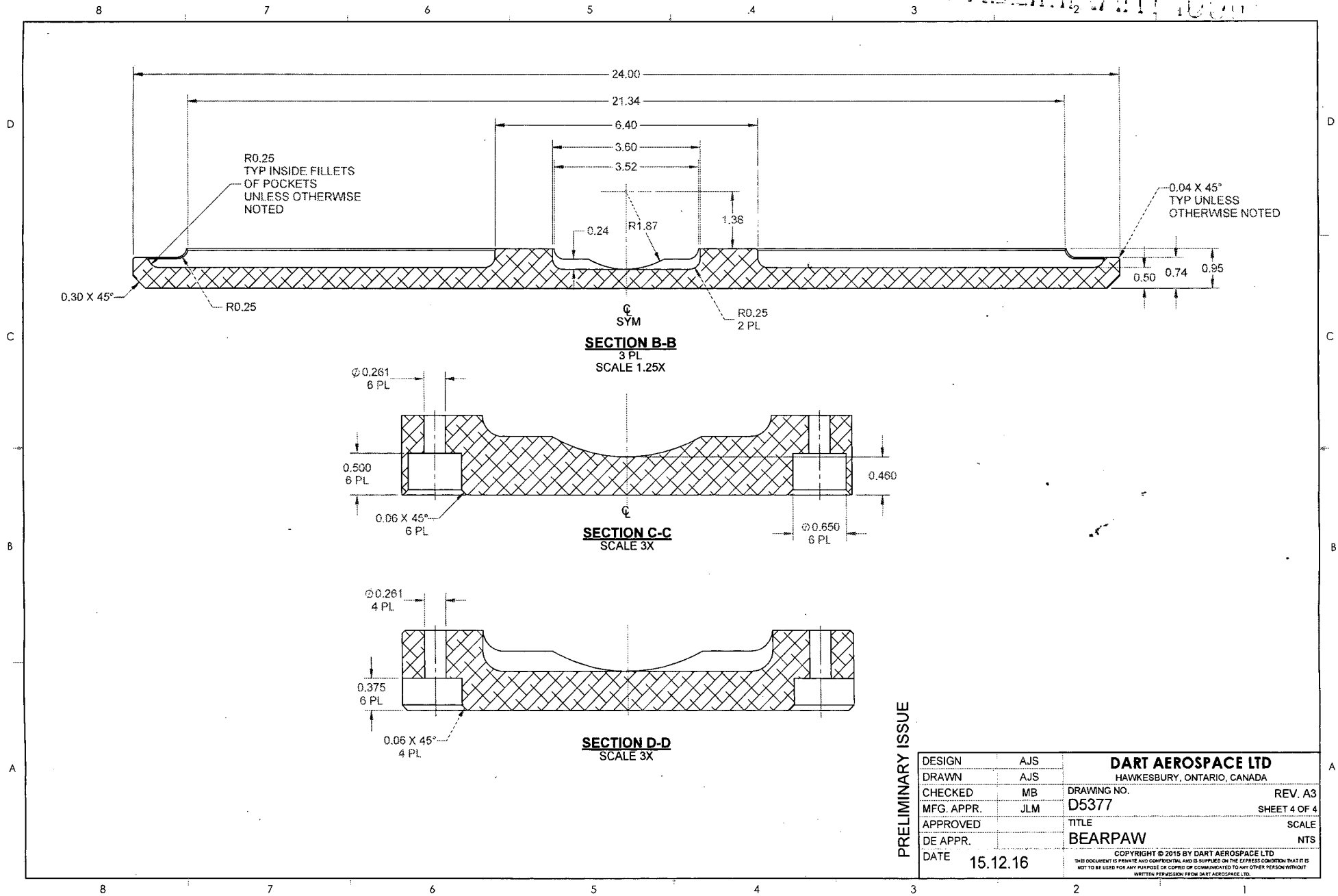
PRELIMINARY ISSUE



PRELIMINARY ISSUE

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CHECKED	MB	DRAWING NO.	REV. A3
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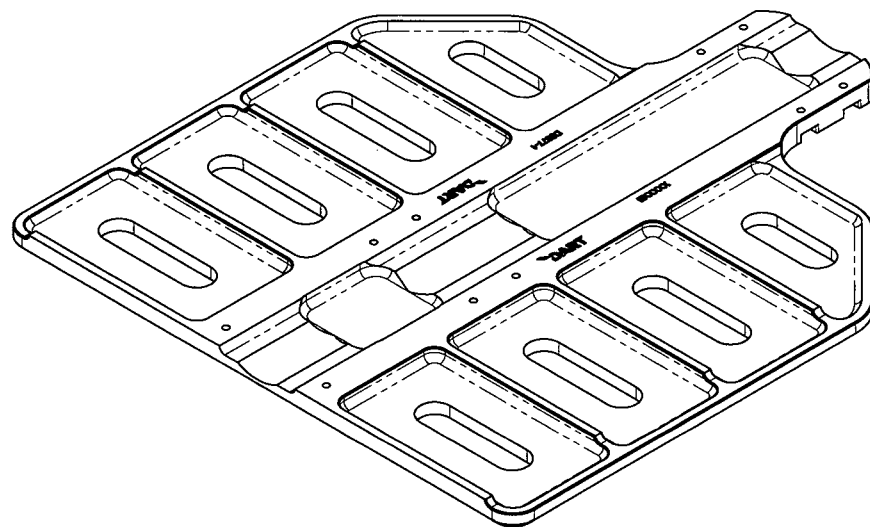
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. A3
MFG. APPR.	JLM	D5377	SHEET 4 OF 4
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DQA: SAF Date: 16-01-13QA Closed: SAF Date: 16/03/01

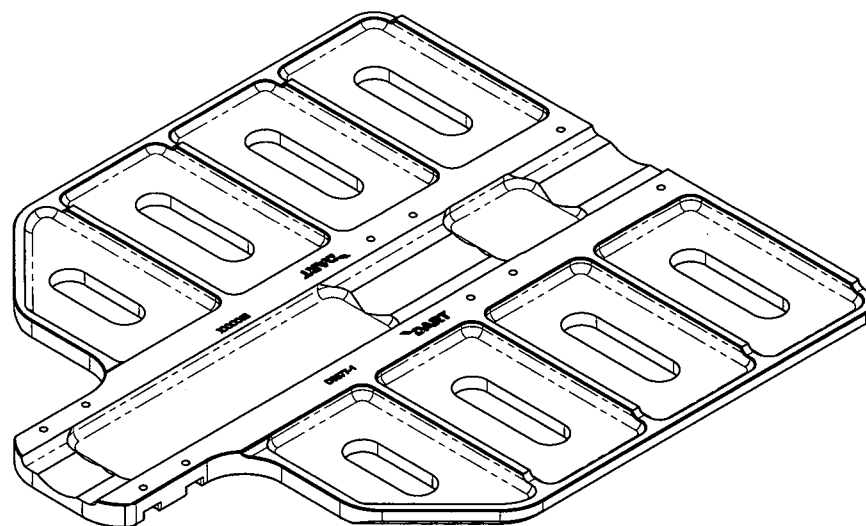
WORK ORDER NON-CONFORMANCE / UPDATE

DART
AEROSPACEWork Order update only ☐

Work Order: <u>140 601</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>D5377-1</u>		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>16-5665</u>		Scrap ☒		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: <u>16-01-13</u>	Step #: <u>130</u>	QTY Effective: <u>1</u>				MRB (QSI042) Approval			
Description Work Order Deviation		Disposition				DAS 9 9-89 <u>16-01-14</u>			
Holes in blank were not well positioned Resulting in the part not being machined on one side		Modified the hole locations on the blanks				Completed By DAS <u>20</u> 9-89 <u>16-01-13</u>			
R.C.		Program on water jet was modified to accommodate more play at machining opp.				Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>16-01-14</u>			
		Scrap & destroy 1 no replace				QC / QA Coordinator Approval DAS 9 9-89 <u>16-01-14</u>			
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☒	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☒	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☒								
Misidentified ☐	Past Due ☐	OTHER: ☐							



D5377-1 BEARPAW

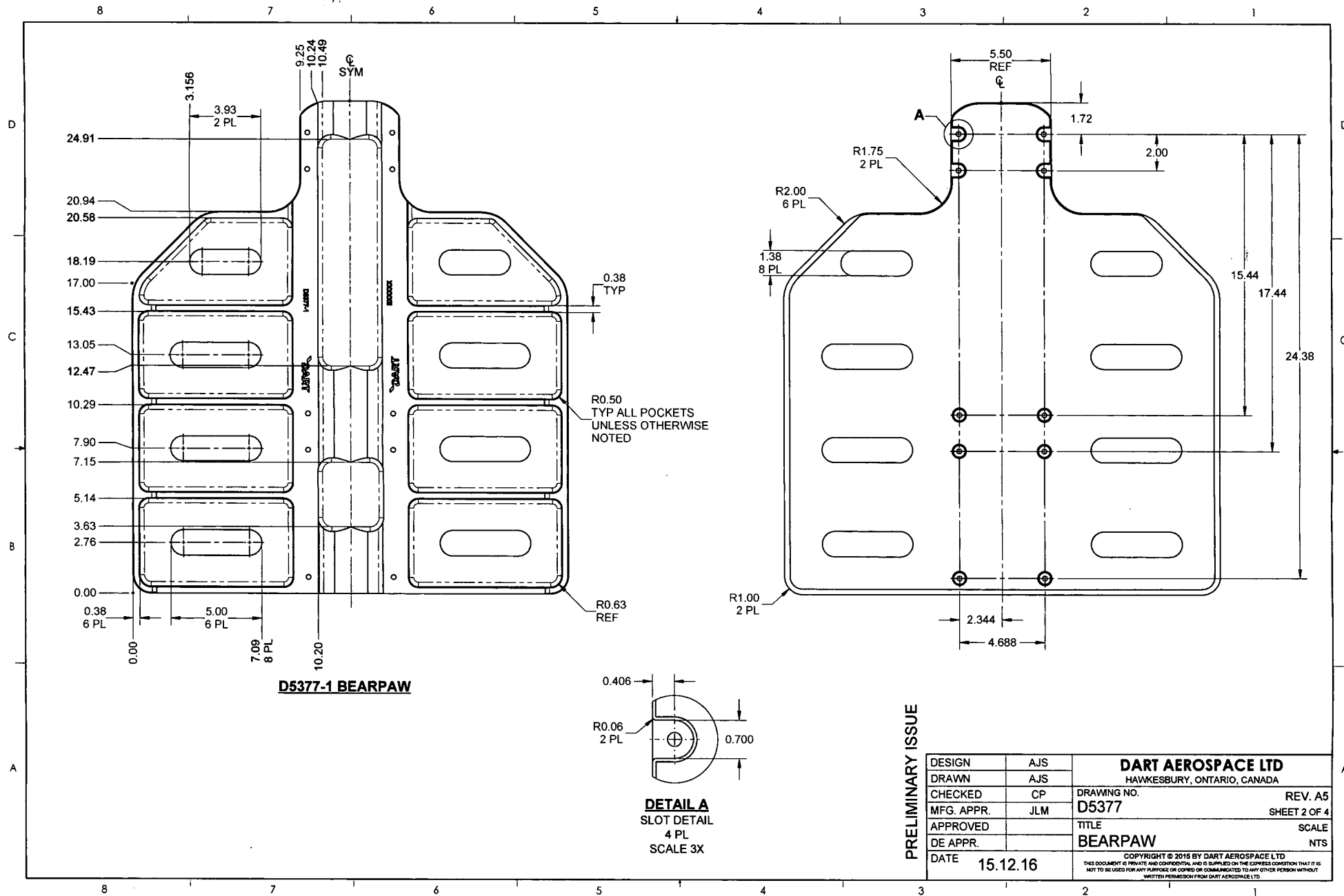


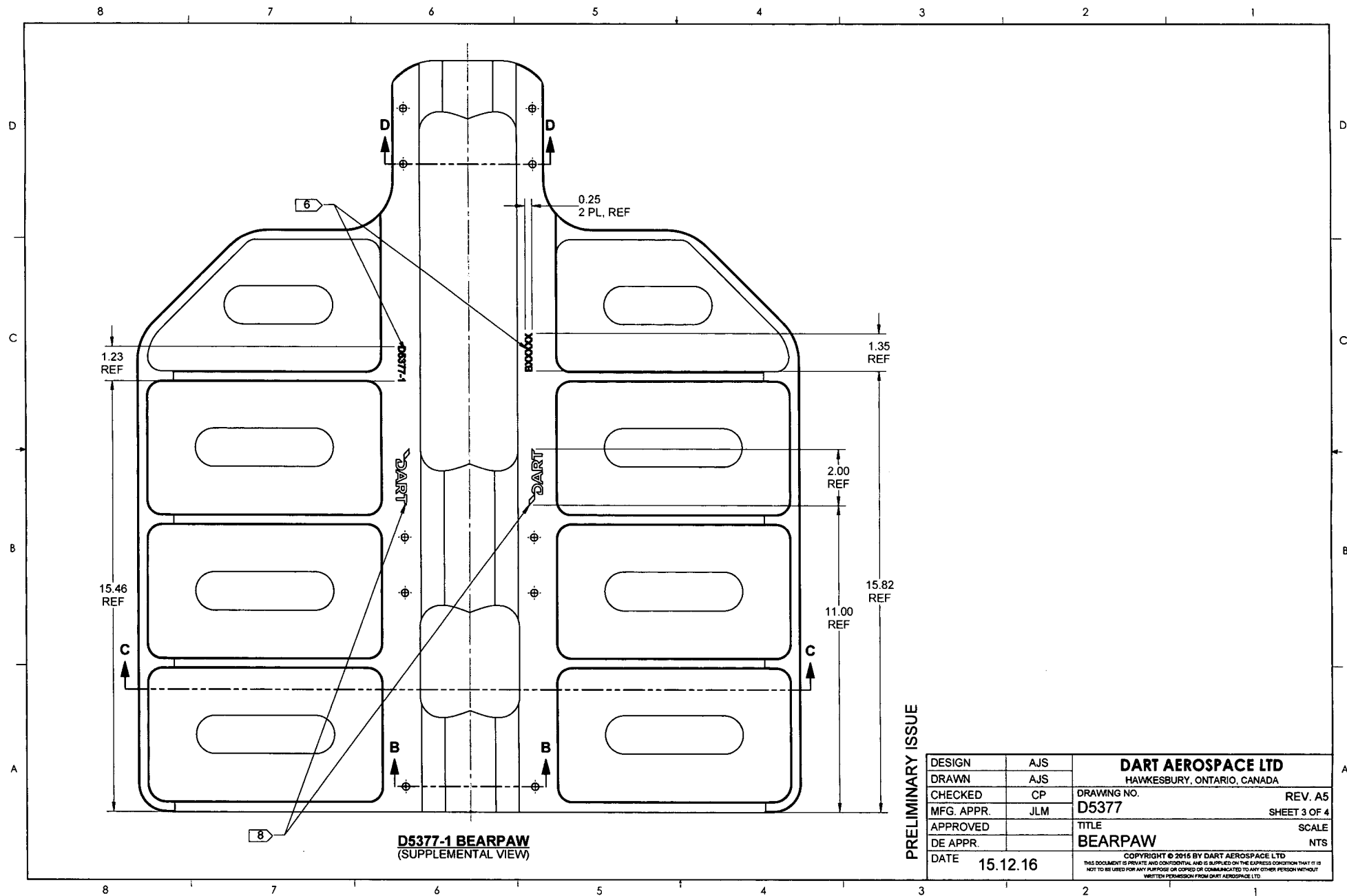
NOTES:

- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK
REF DART SPEC MUHMB100
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 0.010 - 0.012 DP WITH A MINIMUM 0.010 RAD
- 7) WEIGHT: 9.55 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.010 - 0.012 DP WITH A MINIMUM 0.010 RAD
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE D5377-1-REVA.STP

PRELIMINARY ISSUE

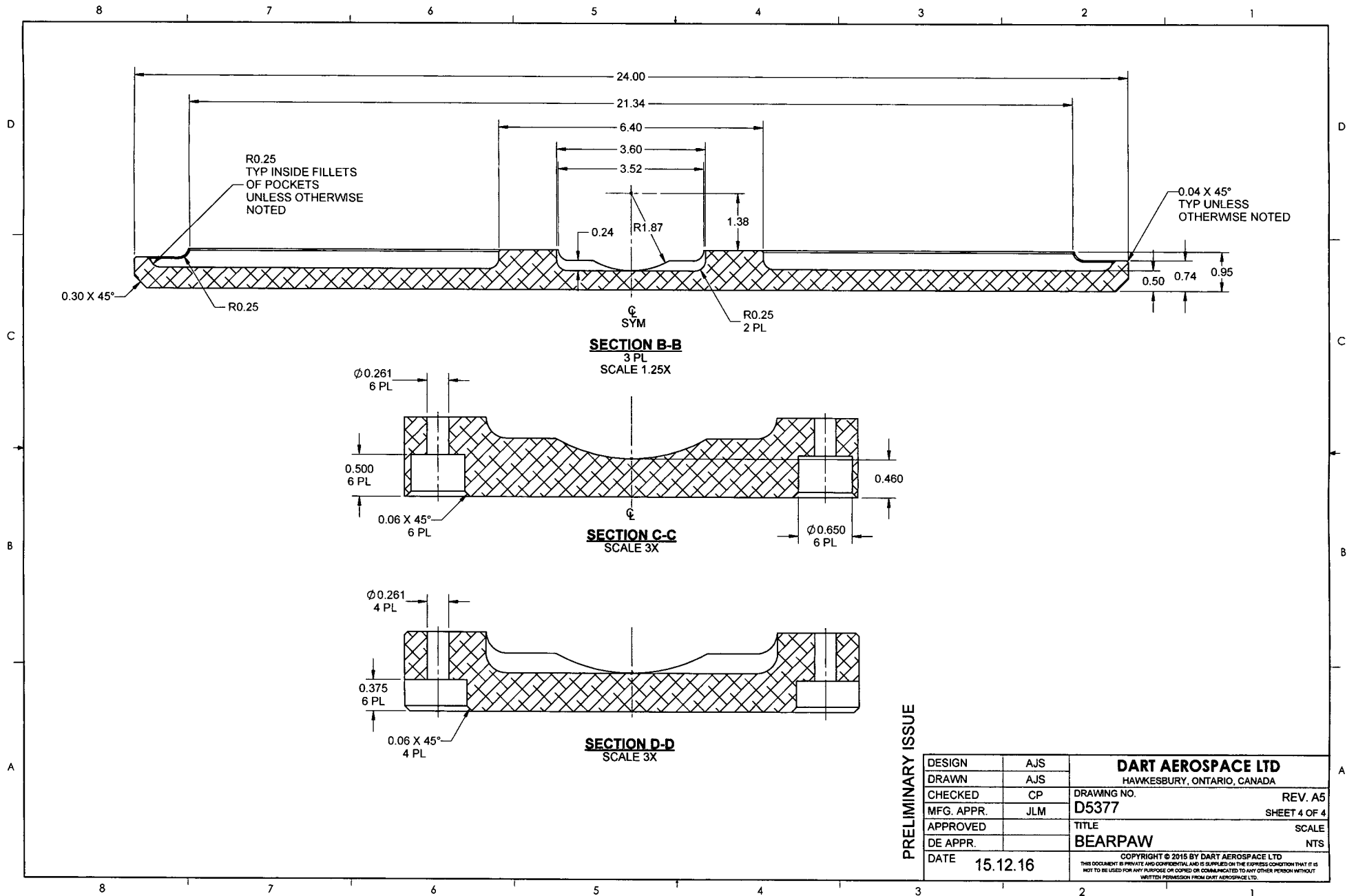
A	NEW ISSUE	AJS	15.12.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CP	DRAWING NO.	REV. A5
MFG. APPR.	JLM	D5377	SHEET 1 OF 4
APPROVED		TITLE	SCALE
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PRELIMINARY ISSUE

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CP	DRAWING NO. D5377	REV. A5
MFG. APPR.	JLM	TITLE BEARPAW	SHEET 3 OF 4
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DATE	15.12.16		



Purchase Order Receipt Listing

Page 1 of 1

Thursday, November 19, 2015 11:07:41 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO30469 All Receipt Dates All Line Item Types

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Sid	PO U/M/ Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-GE001	SABIC Innovative Plastics Canada Inc.								
PO30469	1		MUHMWB10	sf	11/19/2015	11/19/2015	400.0000	\$24.58	0.0000	0	\$9,832.27
CAD	No		UHMW 1" Black - 48"x120" Tivar Mfg.#52480104 m133642	sf	400.0000	DCUSER		\$9,832.27	0.0000	0	
	2		71401-45		11/19/2015	11/19/2015	1.0000	\$0.00	0.0000	0	\$0.00
	No		PROCUREMENT QUALITY CLAUSES m133642		1.0000	DCUSER		\$0.00	0.0000	0	

SABIC POLYMERSHAPES

Ship To:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A 1K7
CANADA
Telephone - 1 (613) 6325200

Bill To:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A 1K7
Canada

PACKING SLIP

DATE:
17-NOV-15

ORDER:
99011337

PMT TERMS:
CA NET 30

F.O.B.

WAREHOUSE: OTTAWA ON - SABIC POLYMERSHAPES
1290 Old Innes Road, Unit 713, Ottawa, ON, K1B 5M6, CA

PURCHASE ORDER:
PO30469

FRT TERMS:
Collect Freight

SALES REPRESENTATIVE:
DIXON, WADE

CONTACT NUMBER:
0014005000120

ORDER DATE:
16-NOV-15

DELIVERY NAME
28459918

WAYBILL NUMBER:
73642741106

FREIGHT CARRIER:
TST OVERLAND EXPRESS

FREIGHT CHARGE COMMENT:
CLAVOIE@DARTAERO.COM

LINE	PART NUMBER/ ITEM DESCRIPTION	SHIP DATE	QTY ORDERED	QTY SHIPPED	QTY BACKORD	UOM
1	52480104 UHMW SH 1.000 48X120 BK EXTRUDED TIVAR 1000	17-NOV-2015	10	10	0	SH

SPECIAL INSTRUCTIONS:

LOT Numbers:
(10 Qty)

RECEIVING IN GOOD CONDITION

Signed:

Date:

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*** End Of Report ***



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO30469

Purchase Order Date 11/16/2015 2:25:41 PM

PO Print Date 11/16/2015

Page Number 1 of 2

Order From :

VC-GE001

Ship To : DART AEROSPACE LTD

SABIC POLYMERSHAPES
1290 OLD INNES ROAD
UNIT 713
OTTAWA, ON K1B 5M6
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone 800 267 1575

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Ship To Contact

Terms Net 30

Ship To Phone

Currency CAD

Ship Via: TST ground

FOB FCA - (Free Carrier)

Ship Acct:

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments			Promise Date				
Delivery Comments							

1	MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	11/19/2015	FN	400.00 ✓	\$32.14	\$12,856.00
---	----------	--	------------	----	----------	---------	-------------

Yes
11/19/2015

MATERIAL: UHMW BLACK TRIVAR 1000 VIRGIN MATERIAL
MANUFACTURER: POLY HI SOLDUR/QUADRANT PLASTICS

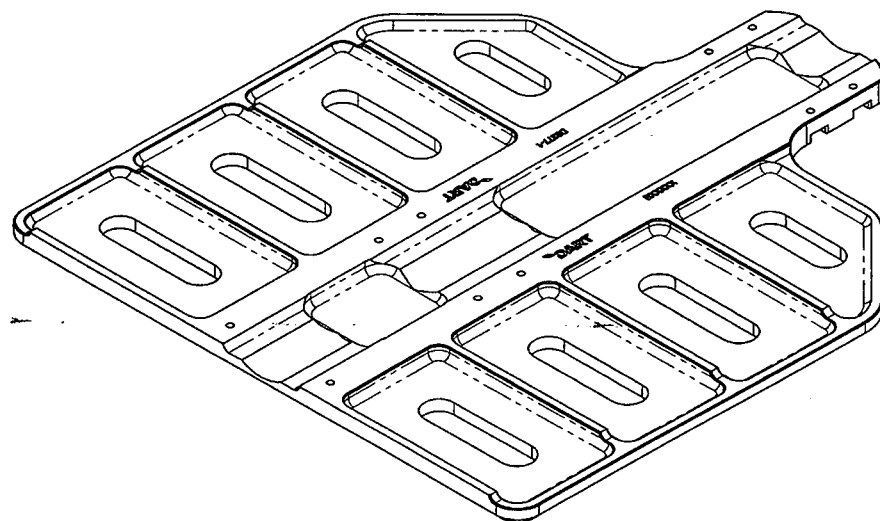
NOTE: PLANNED BOTH SIDES

SP15-11-19

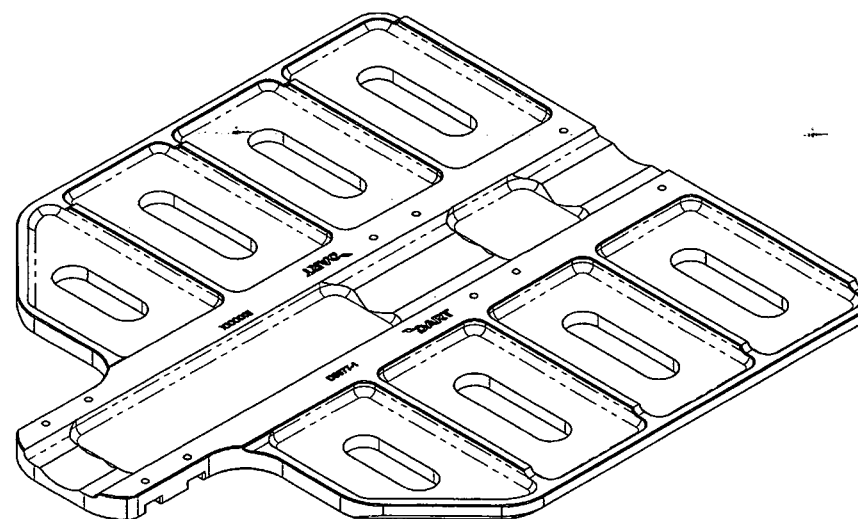
Line Total: \$12,856.00

Note:

11/16/2015



D5377-1 BEARPAW



NOTES:

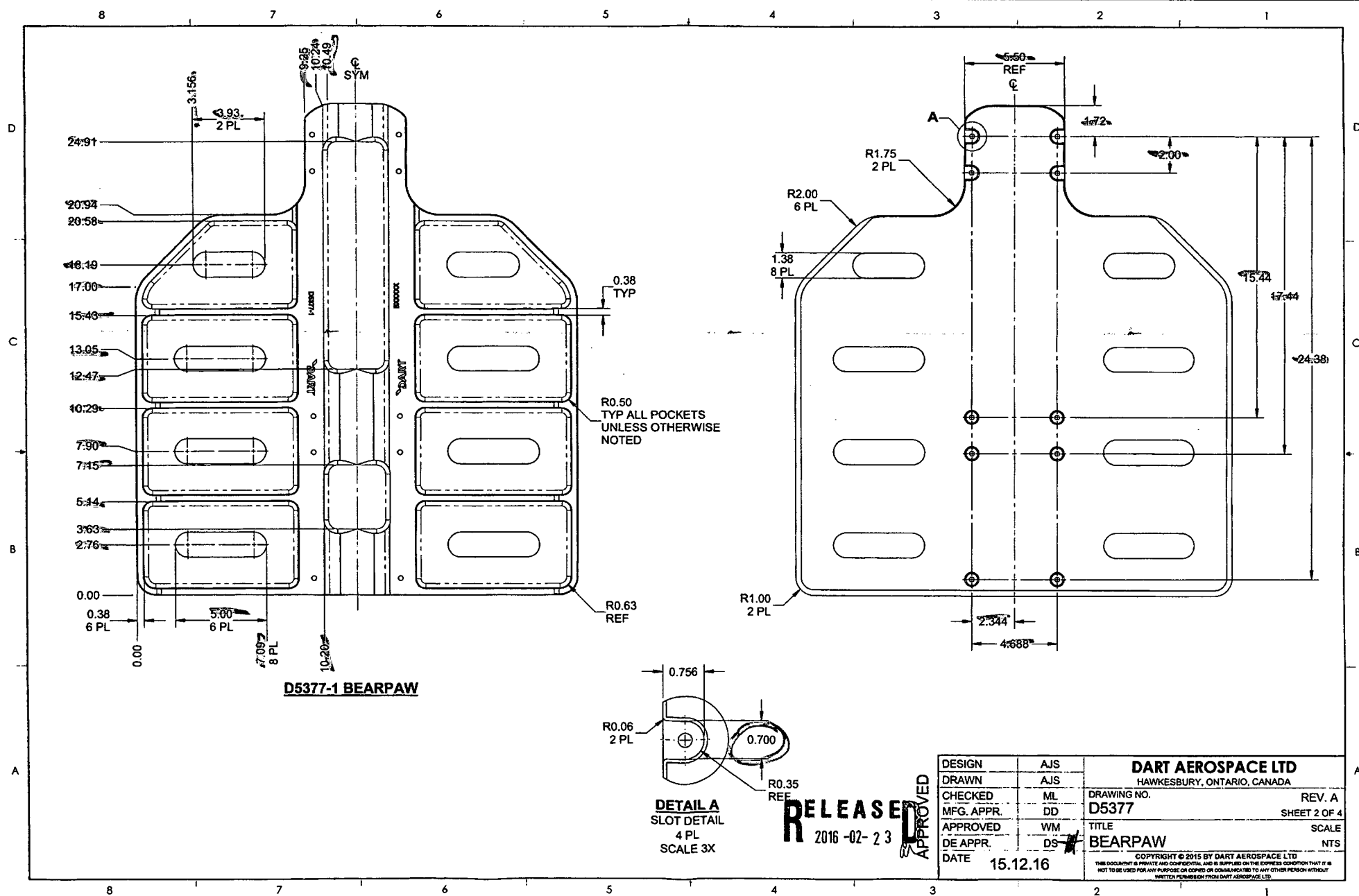
- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK
REF DART SPEC MUHMBW100
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 0.010 - 0.012 DP WITH A MINIMUM 0.010 RAD
- 7) WEIGHT: 9.55 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.010 - 0.012 DP WITH A MINIMUM 0.010 RAD
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE D5377-1-REVA.STP

RELEASED
2016-02-23
EW 4-529

APPROVED

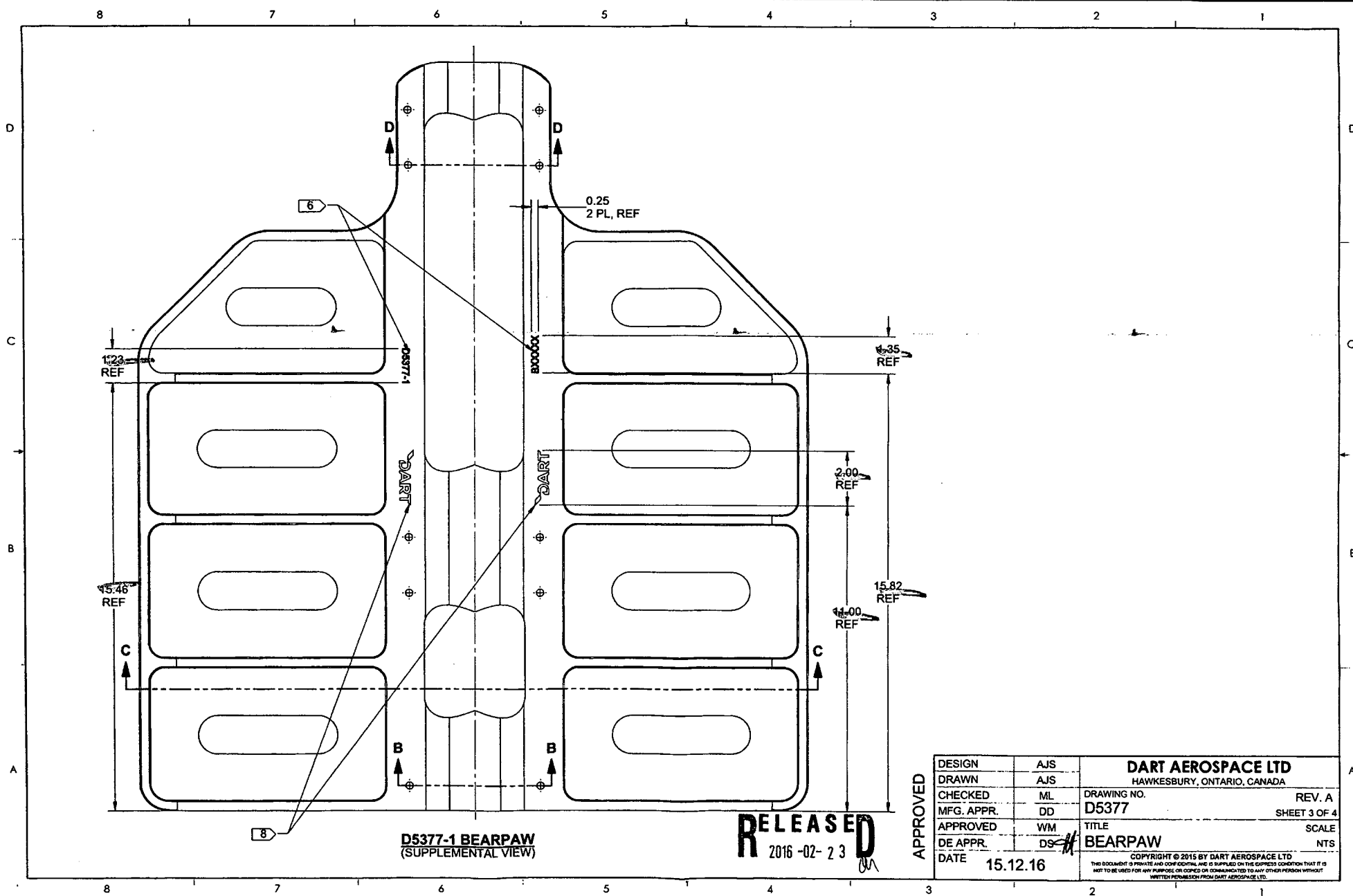
A		NEW ISSUE		AJS	15.12.16
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS				
CHECKED	ML	DRAWING NO. D5377			REV. A
MFG. APPR.	DD				SHEET 1 OF 4
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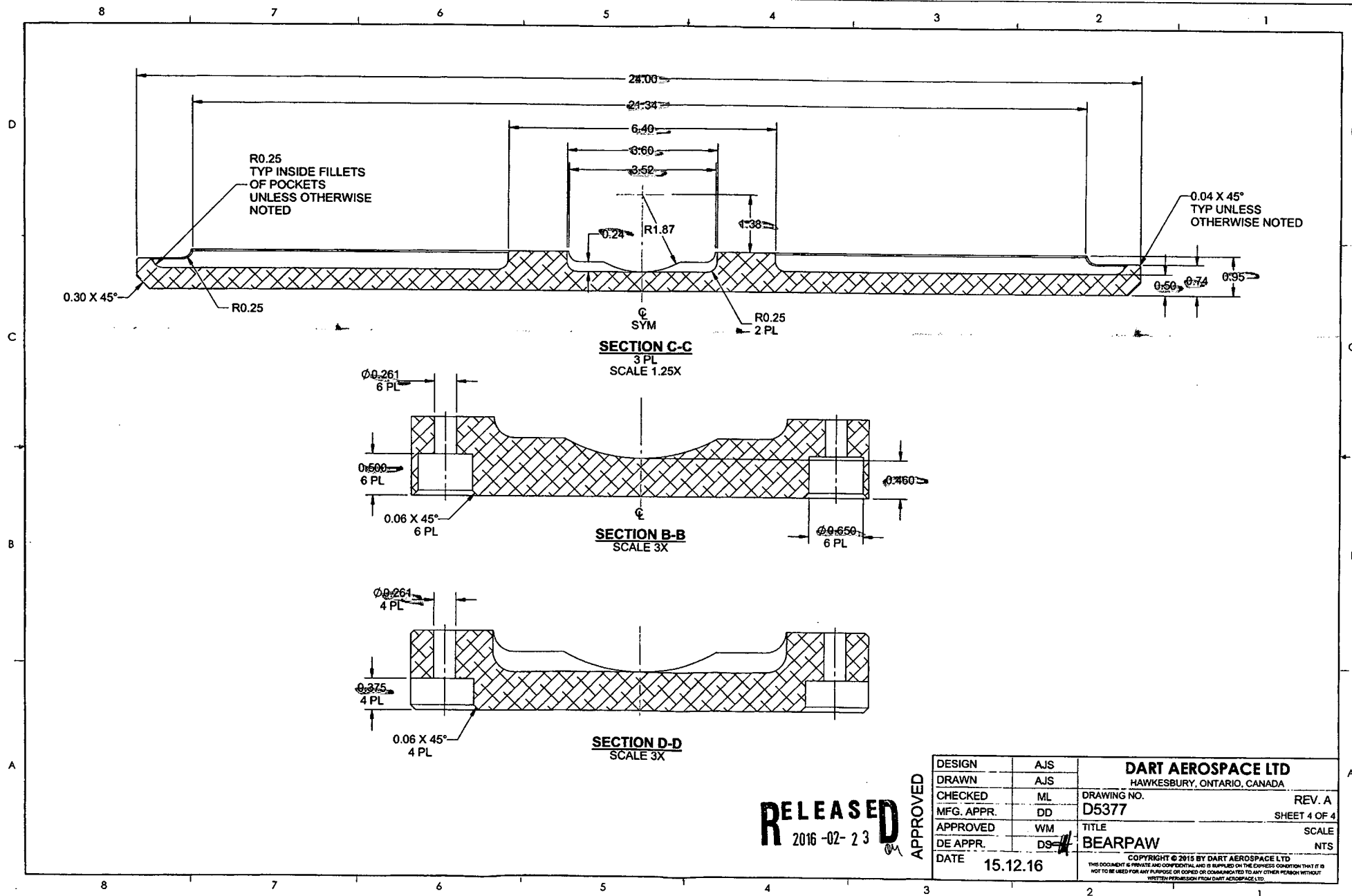
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MFG. APPR.	DD	D5377	SHEET 2 OF 4
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MFG. APPR.	DD	D5377	SHEET 3 OF 4
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